

Work Order ID 84689

84689

Page 1

May-22-12 1:00:31 PM

Item ID: D135-692-011

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 22/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 12/05/22

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3049

Rev A1

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

150

Pick Kit

0.00

150

Packaging

Memo

0.00

Packaging

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

0.00

Quality Control

Salvato

for MLS 12-7-10

4 12/07/10 JB

Salvato

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84689

84689

Page 2

May-22-12 1:00:31 PM

Item ID: D135-692-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 22/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	Packaging					4x			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-692-011								
	Location: _____								
	PPP Rev: <u>C.</u>								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12-7-10

12/7/17

MLJ 12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May-22-12 1:00:35 PM

Page 1

Work Order ID: 84689

84689

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:C04.02.17Blank size changed, Tolerance added Step
3KJ/JLM IPP REV:E AS PER DSI
9592/9587 REV A JLM VERIFIED BY:EC
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A		Purchased	No				Each	1,491.000		32			
<p>S+4 *AN4-13A*</p> <p>BoP</p>													

Location	Loc Qty	Loc Code
ST357	1491	
119449	33	
120187	19	
120422	2	
120770	400	
121162	37	
121652	1000	

AN960JD416	NAS1149D0463J	Purchased	No				Each	30.0000		32			
<p>S+4 *AN960.ID416*</p> <p>Washer</p>													

Location	Loc Qty	Loc Code
ST351	30	
116289	10	
119097	20	

D2182B		Manufactured	No				f	138.5952	2	8			
<p>*D2182R*</p> <p>Rubber Cushion</p>													

Location	Loc Qty	Loc Code
ST410	138.59517	
63413	1.6	
66063	41.61817	
73932	95.377	

(D2182B060) Cut 4 at 6.00"

→ marked
8/12/07/10

73932

JB 12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May-22-12 1:00:35 PM

Page 2

Work Order ID: 84689

84689

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2274

Manufactured No

160

Each

376.0000

8

32

**

3084199

JB



D2274

Radius Block

Location

Loc Qty

Loc Code

ST007

376

78233

2

81958

164

83258

210

2x 78233

D2519

Manufactured No

160

Each

11.0000

4

16

**

79480

JB



D2519

Clamp

Location

Loc Qty

Loc Code

ST459

11

73499

11

3x 73499

D2529

Manufactured No

160

Each

765.0000

8

32

**

JB

12/07/10

D2529

Washer

Location

Loc Qty

Loc Code

ST010

765

79485

18

81873

247

84435

500

84435

D3049-1

Manufactured No

160

Each

0.0000

2

8

**

84700

JB



D3049-1

Bearpaw

May-22-12 1:00:35 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

May-22-12 1:00:35 PM

Page 3

Work Order ID: 84689

84689

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

160

Each

4,654.000

8

32

**

JB

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

4654

119075

125

121011

1266

121444

2963

121652

300

15x121444

17421652

QS100-M24S

Purchased

No

160

Each

21.0000

4

16

**

JB 12/07/10

QS100-M24S

Clamp

Location

Loc Qty

Loc Code

ST452

21

120521

1

120820

20

1x120521

15x120820

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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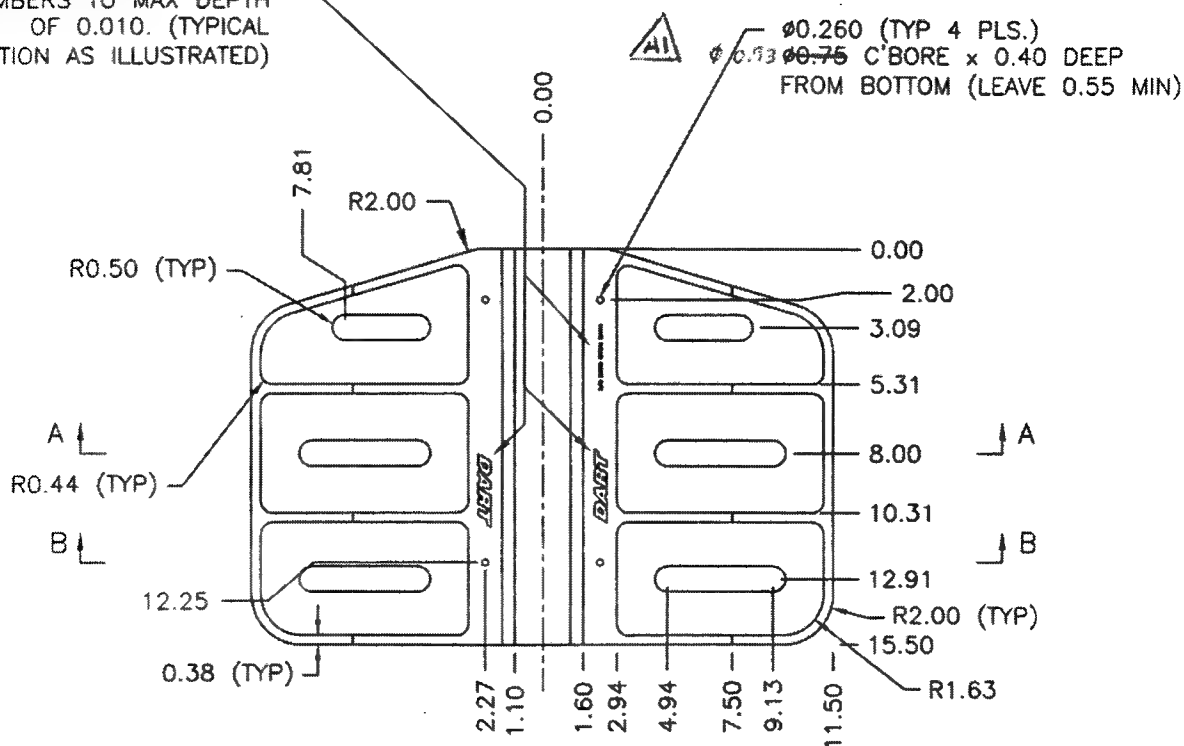
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:1
A	01.10.18	NEW ISSUE	
AI	03.01.13	Ø 0.73 w 45 Ø 0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21685 M.C.
12/05/22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

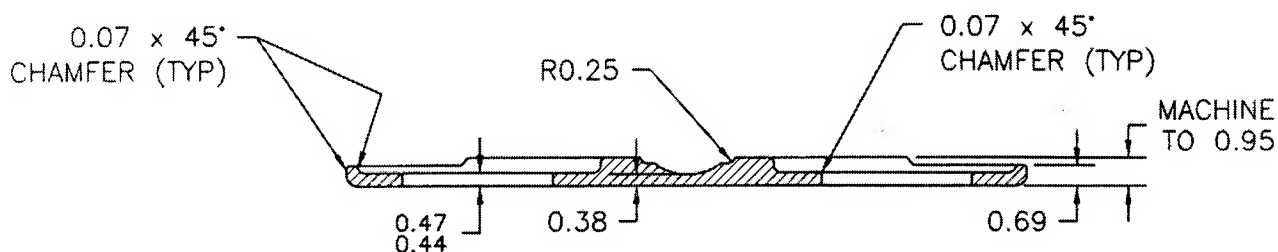
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE; Date & initial all entries

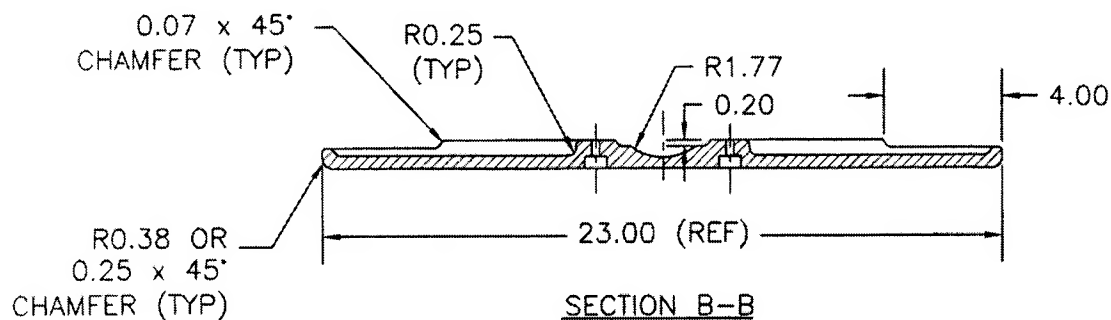


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 H



SECTION A-A



SECTION B-B

01689

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
6. Lower the aircraft

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 Bearpaw Installation on model EC135 aircraft	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D3049-1	BEARPAW
8	D2529	WASHER
4	D2519	CLAMP
8	AN4-15A	BOLT
8	AN960JD416	WASHERS
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-692 REV. 0

REF. FAA STC: SR01042SE

REF. TCCA LETTER OF ACCEPTANCE: 120S-GA-08-52

REF. UK STC: AAN #28700

PURPOSE:

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO CORRECT A DISCREPANCY IN SECTION 32.4 OF ICA-D135-692 REV. 0.

CHANGE:

FOR D135-692-011 BEARPAW INSTALLATION, THE D2519 CLAMP QTY(8) SHOWN IN THE PARTS LISTS IS UPDATED AS INDICATED BELOW:

32.4 PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION

IS:

4	D2519	CLAMP
---	-------	-------

WAS:

8	D2519	CLAMP
---	-------	-------

A	NEW ISSUE	(REF CAR11-60)	MB	12.01.18
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC		
DRAWN		KENT, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9592	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		PARTS LIST CORRECTION	NTS	
DATE	12.01.18	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		